D 3025 - 1
B 116910

Work Order ID 116910

ASAP

116910

April-24-14 8:35:50 AM

Item ID: D3025-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Beam
Start Date: 4/28/14 **Start Qty:** 400 10 *4*
Required Date: 4/28/14 **Req'd Qty:** 400 *4*
Cust Item ID:
Customer:
Reference:

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr: D3025 / Revision Nbr: B									
100	FLOW WATER JET	0.00				6	mm	14/05/14	DAS 37 9-89
100 Waterjet FLOW CNC Waterjet	**Memo** 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary	0.00							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				6	mm	14/05/14	DAS 37 9-89
110 QC Quality Control	**Memo**	0.00							
120	QC8- Inspect parts - second check	0.00				6			
120 QC Quality Control	**Memo**	0.00							

DAS 27 9-89
14/5/15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 116910

April-24-14 8:35:50 AM

116910

Item ID: D3025-1 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Beam

Start Date: 4/28/14 **Start Qty:** 4.00 *4*

Required Date: 4/28/14 **Req'd Qty:** 4.00 *4*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Bend as per dwg	0.00			DAS 30 9-89	6			4/05/15
130	NC BRAKE								
Brake NC	**Memo**	0.00							
Brake NC									
131	QC5- Inspect part completeness to step on W/O	0.00			DAS 27 9-89	6			
131									
QC	**Memo**	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00				6	MB 4/5/16		
140									
HandFinish	**Memo**	0.00							
Hand Finishing									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
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☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
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☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D3025-1 **Accept** *N9000401 00* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Beam

Start Date: 4/28/14 **Start Qty:** 4.00 *4* **Cust Item ID:**
Required Date: 4/28/14 **Req'd Qty:** 4.00 *4* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00				Lex		14-5-20	DAS 26 9-89
150									
QC	**Memo**	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: SC/77	0.00				Lex		14-5-20	DAS 26 9-89
160									
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00				MCS		14-05-21	
170									
QC	**Memo**	0.00							
Quality Control									

MCS 14-05-21

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Crushing
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General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
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☐ Countersink
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☐ Drawing
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☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

April-24-14 8:35:54 AM

Work Order ID: 116910 *116910*

Parent Item: D3025-1 *D3025-1*

Parent Item Name: Beam

Start Date: 4/28/14 **Required Date:** 4/28/14

Start Qty: 4.00 **Required Qty:** 4.00

Comments: IPP C01.10.26Added Bending as per Drawing. SM IPP REV:D
11.05.16 MAT'L THIKNESS CHG DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080		Purchased	No			100	sf	102.7590	0.75	3.157895 4.5			
M2024T3S.080									**				
2024-T3 .080 sheet													

mm 14/05/14

Location	Loc Qty	Loc Code
MAT022	102.759	
M127668	102.759	

7.9

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Folio/Program
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☐ Hardware
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☐ Instructions Incomplete/Unclear
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☐ Part Lost/Missing
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☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	11690
Description: Beam	Part Number:	D3025-1
Inspection Dwg: D3025 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

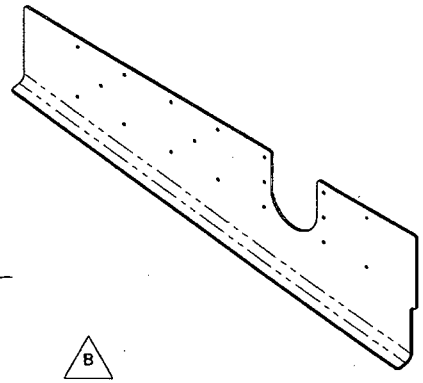
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	0.098	✓		U- JLM-05	
0.25	+/-0.030	0.25	✓		I- JLM-07	
5.78	+/-0.030	5.78	✓			
3.00	+/-0.030	3.00	✓			
2.395	+/-0.010	2.395	✓			
1.385	+/-0.010	1.385	✓			
0.375	+/-0.010	0.375	✓			
2.332	+/-0.010	2.332	✓			
4.365	+/-0.010	4.365	✓			
4.68	+/-0.030	4.68	✓			
6.92	+/-0.030	6.92	✓			
7.235	+/-0.010	7.23	✓			
9.470	+/-0.010	9.47	✓			
10.587	+/-0.010	10.58	✓			
11.705	+/-0.010	11.70	✓			
13.940	+/-0.010	13.940	✓			
15.057	+/-0.010	15.057	✓			
16.175	+/-0.010	16.175	✓			
18.75	+/-0.030	18.75	✓			
0.080	+/-0.010	0.081	✓			

Measured by: DAS 37 9-89	mm
Date:	14/05/14

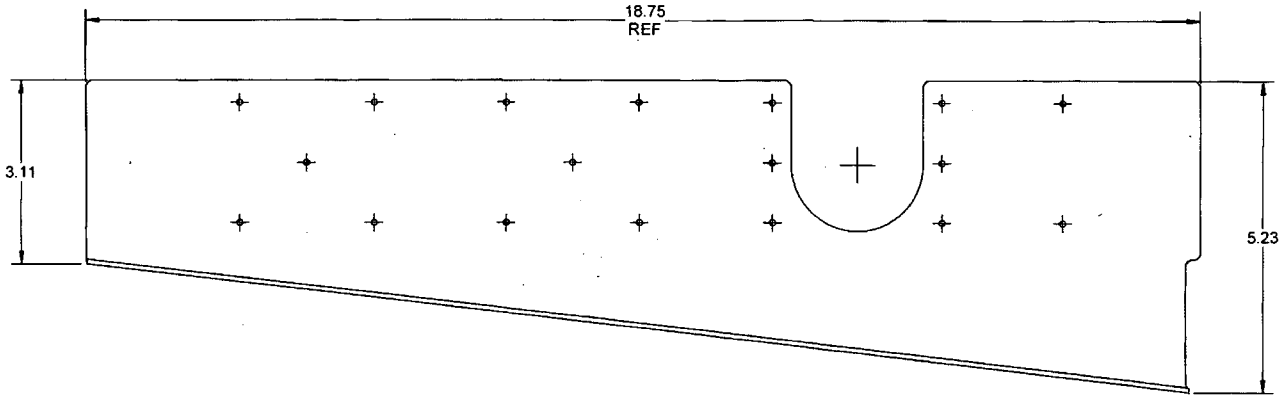
Audited by: DAS 27 9/89	
Date:	14/5/15

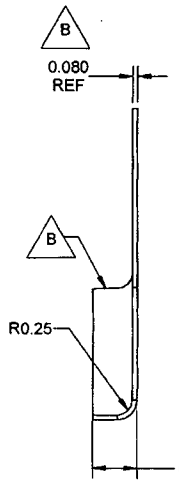
Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D350-689-013	KJ/JLM	
B	12.07.31	Dimensions updated per Dwg Rev B	KJ	



116910 MCJ
14-04-25





D3025-1 BEAM

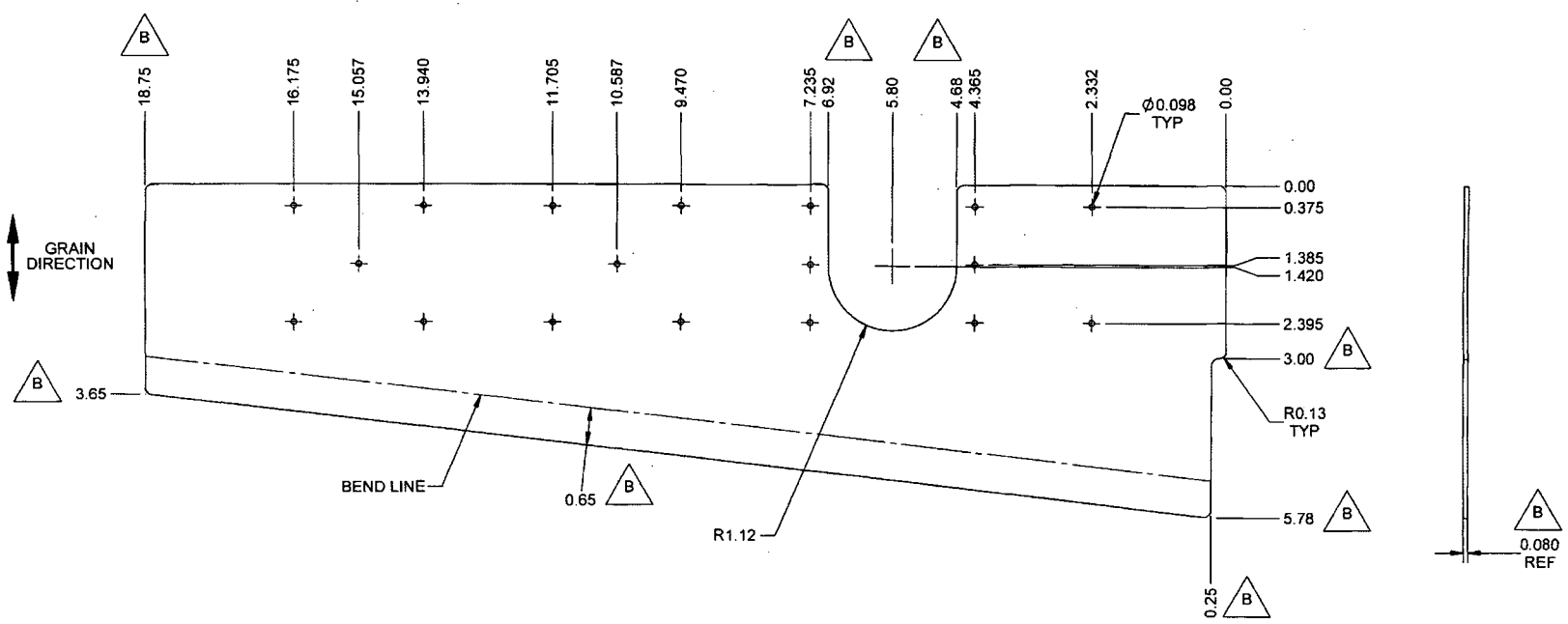
RELEASED
2011 -05- 18

NOTES:
1) MATERIAL: MAKE FROM D3025-1F FLAT PATTERN
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.67 lbs

REV.	DESCRIPTION	BY	DATE
B	5.78 WAS 6.564 (ZN B2-2); 0.080 WAS 0.050 (ZN C2-1 & B1-2); DIMENSIONS CHANGED TO 2 DEC PLACES; REVERSE BEND	RF	11.05.11
A	NEW ISSUE	RF	01.05.18

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3025	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BEAM	NTS
DATE	11.05.11		

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D3025-1F FLAT PATTERN

RELEASED
2011 -05- 18

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037
OR ASTM B209
REF DART SPEC M2024T3S.080
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.67 lbs

DESIGN	RF	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3025 REV. B
MFG. APPR.		SHEET 2 OF 2
APPROVED		TITLE BEAM SCALE NTS
DE APPR.		
DATE	11.05.11	

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